

535

69.m

DART AEROSPACE LTD	Work Order:	24067
Description: Lug	Part Number:	D2591
Drawing: D2591 Rev. D	Qty:	40

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	JL	05.08.12	40
2	METAL	Cut blanks: 2.700" long Material: ASTM A36 steel bar 2.50" X 0.75"" thick Batch: M17684	CP	05.08.12	40
3	HAAS	Machine per Folio FA039	JL	05.08.31	40
4	QC	Inspect Level 2	JL	05.08.31	40
5	QC	Inspect Level 8	ML	05/08/31	40
6	METAL	Tumble	N/A		
7	METAL	Deburr after tumbling if necessary	JL	05.08.31	40
8	QC	Inspection Level 5	ML	05/08/31	40
9	STORES	Identify and Stock	CD	05.09.01	40
10	EXPEDITING	Close W/O Inspection Level 21 Cost/part: 8.30 suc on 08/02 40	DP	05/08/02	40

Rev	Date	Change	Revised By	Approved
C	98.01.21	Changed Rev of Dwg	BW	
D	98.04.17	Re-format	KB	
E	99.07.06	Re-format, Added bevel	DM	
F	99.09.14	Remove bevel, added tumble	EC	
G	00.03.15	Now goes on Haas	EC	
H	01.11.29	Reformat	SM	EC

RELEASED

UNDER REVIEW

03.06.05 RF

PL 01.11.30

combine with

D205-641-01

Add 9161

PL 04.12.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.08.31	3	1 part lifted in vise	J.S. C.R.M.D.	- scrap + replace	J.L. 05.08.31	J.S. 05.08.31	J.S. 05.08.31	J.S. 05.08.31

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 NoDQA: 

Date: 05/09/02

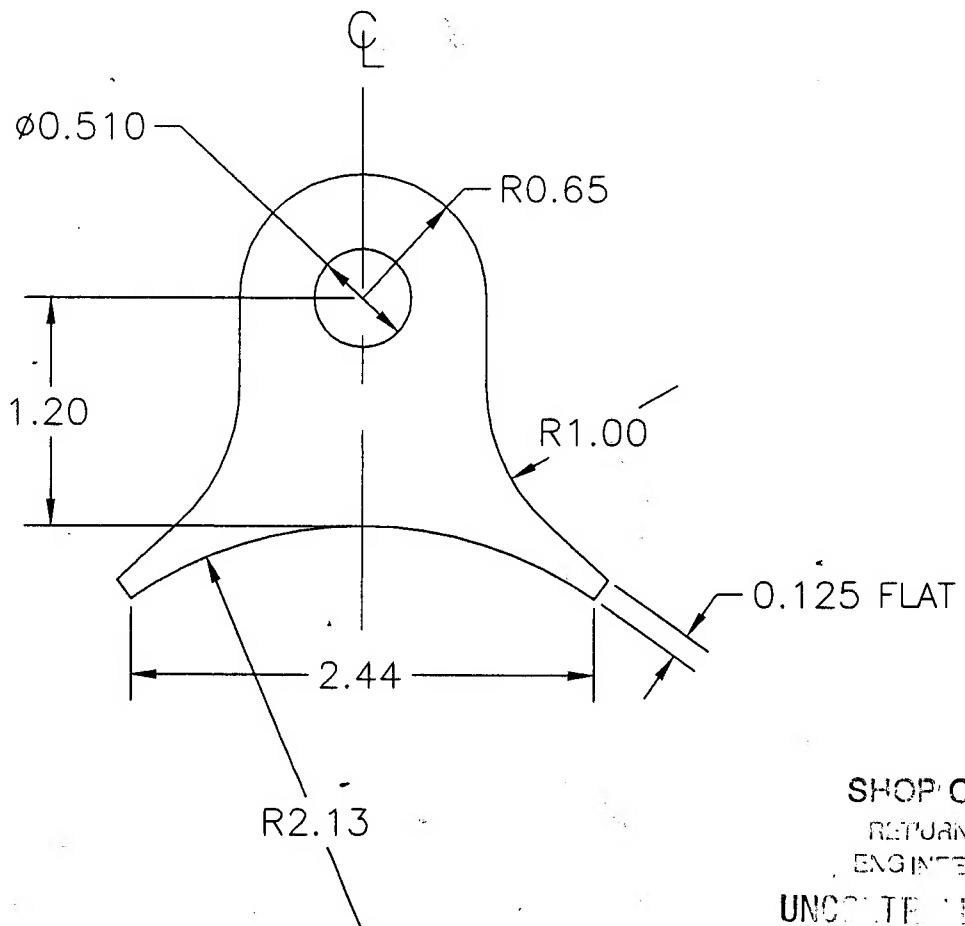
NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

**DART**

DESIGN <i>Moy</i>	DRAWN BY <i>Moy</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

**RELEASED**  
98.01.21 DS

SHOP COPY

RETURN TO  
ENG INGINGUNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 24067

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyAug 11, 2005  
01:37 pm

Work Order No : 0024067  
 Project Name : D2591  
 Project For : WK535  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D2591  
 Description : Lug  
 Manufactured : Yes  
 Amount Req'd : 40  
 Amount Done : 0  
 Start Date : 08-11-05  
 Est Finish Date : 08-31-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :

Department Code:  
 Burden Flags : NNNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00

DART AEROSPACE LTD	Work Order:	24067
Description: Lug	" Part Number:	A 2591
Inspection Dwg: A2591	Rev:	1

## FIRST ARTICLE INSPECTION CHECKLIST

First Article       Prototype

Measured by:	J.L	Audited by:	C.S	Prototype Approval:	
Date:	05.08.30	Date:	05/08/30	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	